



Dart Aerospace Ltd.
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RB072610-H-B-B01
Job Sheet 189899



Part No: RB072610-H-B-B01

Job Qty: 2 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 3/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB072610-H-B Rev.1 IPP Rev. A 19.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	2 pcs	3/27/19		0.00	2.00	Large Fab - 1		CL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
115	QC 9	2 pcs	3/27/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	2 pcs	3/27/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		DAS 43 9-89
							QC 5 - 58		
							QC 5 - 68		



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Container No: S170067



Part: RB072610-H-B-B01

Job No: 189899

Serial No/Batch: S170067

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 04/05/19

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130 Powdercoat - 13 Yellow - B4B 2 pcs	3/27/19	0.00 0.20	QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			Powdercoat - 1 - B4B	
140 QC 3 2 pcs	3/27/19	0.00 0.00	Powdercoat - 2 - B4B	BK 19-04-11
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
			QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 26	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 38	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
180 Packaging 3-1 - Stock - B4B 2 pcs	3/27/19	0.00 0.00	QC 3 - 6	
			QC 3 - 68	APR 11 2019 88
			QC 3 - 9	9-89
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	DAS
			Packaging 3 - 6 - B4B	28
			Packaging 3 - 7 - B4B	9-89
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	3/27/19	0.00 0.00	QC 21 - SA - 21	DAS 21 APR 12 2019
				QC 21 - SA - 70	

Part Op 110 - 1-Weld as per DWG. ***Ensure hole alignment**

Descriptions: 115 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Powdercoat13 - Yellow #13538 - START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME: 4:00

140 - 1- Inspect Part Finish 2-Ink stamp P/N as per drawing.

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB072610-H-B-B03	Tube	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5189832</u>
RB072610-H-B-B05	Tab	4 pcs (2 ea)	110-Large Fab - Welded Assy-1	<u>5168633</u>
RB072610-H-B-B07	Front	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5157931</u>
RB072610-H-B-B09	Back	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5157769</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	RB072610-H-B-B03	2	0	0
	RB072610-H-B-B05	4	0	0
	RB072610-H-B-B07	2	0	0
	RB072610-H-B-B09	2	0	0

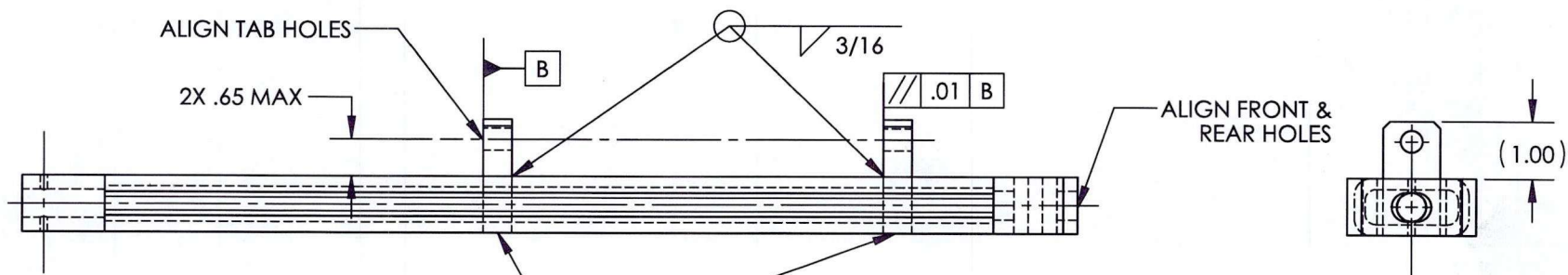
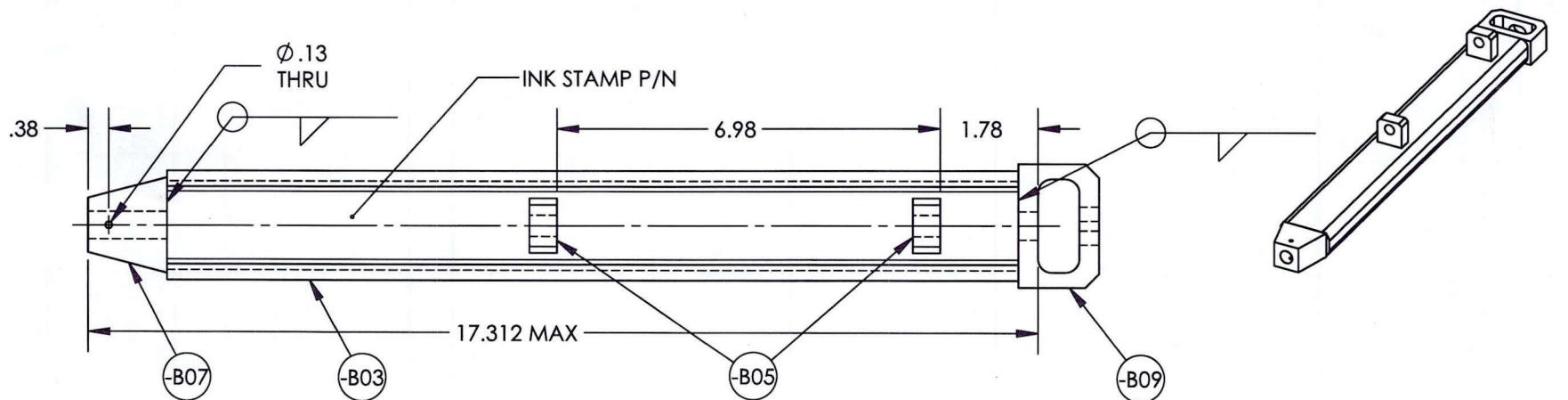
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	15-0110	-B01 CH'D FINISH WAS FORREST T-5920 S9 YELLOW RIBBON IS POWDER COAT YELLOW FED #13538.	5/18/2015	RJC	JAG



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189 899 mws
190131

-B01

WELDMENT

DART AEROSPACE	
TITLE SKID TUBE ATTACHMENT	
DWG NO. RB072610-H-B01	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT POWDER COAT YELLOW SPEC FED #13538 USED ON MODEL BELL 206L, 407, & 427
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 3/9/2011
SHEET 2 OF 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					